

Date: Tuesday, 24/02/2009 1:41:11 PM  
 User: Chantal Lavoie

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 3" SKID EXTRUSION (NO OUTER RIDGE)
<b>Job Number</b> : 46063	
<b>Estimate Number</b> : 10054	
<b>P.O. Number</b> :	<b>Part Number</b> : D26003120
<b>This Issue</b> : 24/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2600 REV D1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> : D1
<b>Previous Run</b> : 43960	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/03/2009 <b>Qty:</b> 69 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>C209/02/24</u>	
<b>Comment</b> : Est. D: 02.09.10 Added DSK 066 KJ/RF	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0

PG

PURCHASING



**Comment:** Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
 PURCHASING

Issue P/O: 8262

a) Extrude as per Dwg D2600

b) Material: 6061-T6 (QQ-A-200/8)

c) Minimum yield tensile strength = 35 ksi

d) Minimum ultimate tensile strength = 40 ksi

e) Minimum elongation = 8%

f) Order at 120" long

g) Bon L Canada Inc. tool # 897122

h) To be packed per DSK 066

i) Pull test to ASTM standard B221 required.

j) Material certification is required

C209/02/24

(69)

2.0

D26003120P

Extrusion Round 3" 350



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 69.0000 Each(s)  
 Extrusion Round 3" 350

3.0

PACKAGING 1

PACKAGING RESOURCE #1



**Comment:** Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
 PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage  
 Ensure material certification is attached

C209/02/24 (77)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 24/02/2009 1:41:11 PM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3" SKID EXTRUSION (NO OUTER RIDGE)

Job Number: 46063

Part Number: D26003120

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC6

DIMENSIONAL CHECK



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

DIMENSIONAL CHECK

Inspect dimension per Dwg D2600

Check Pull test per Dwg D2600 for compliance page attached

Check hardness with Webster tester (16)

*5 09/03/18* *counter* *(77)*

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

PACKAGING RESOURCE #1

Identify and Stock

Location: *skid tube cell*

*MB 09-03-18*

*(77)*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

FINAL INSPECTION/W/O RELEASE

*09/03/19*

Job Completion



*MF 09-03-18*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. 0 SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS + DIE NUMBERS <i>FGP</i>	

RELEASED  
98.08.25 DS

### GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi  
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED  
TO ASTM STANDARD B221 BY AN APPROVED TESTING  
FACILITY TO ENSURE THAT THE BATCH MEETS THE  
ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

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RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 46663

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

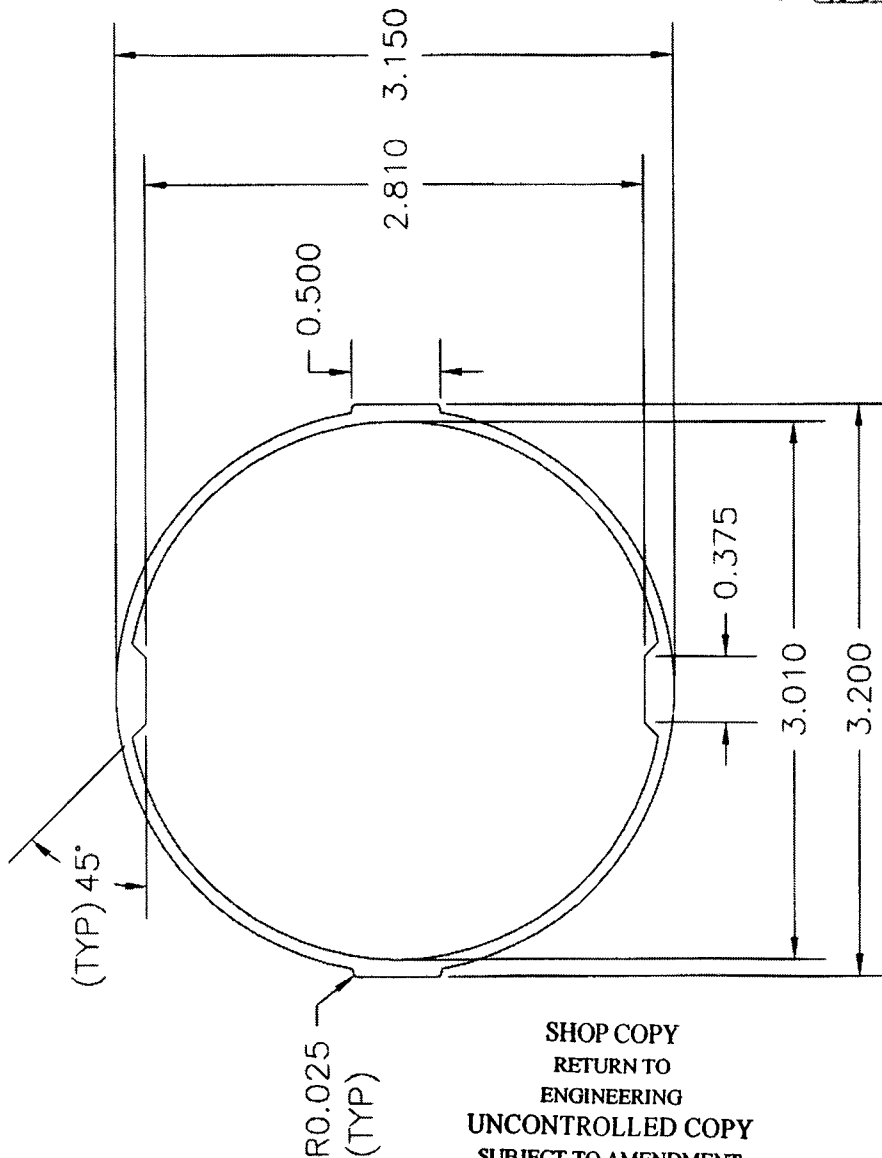
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>DP</i>	DRAWN BY <i>DP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DP</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED  
48 8.25 DS



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D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870

OR 60N L DIE # 897121 (PREFERRED CHOICE)

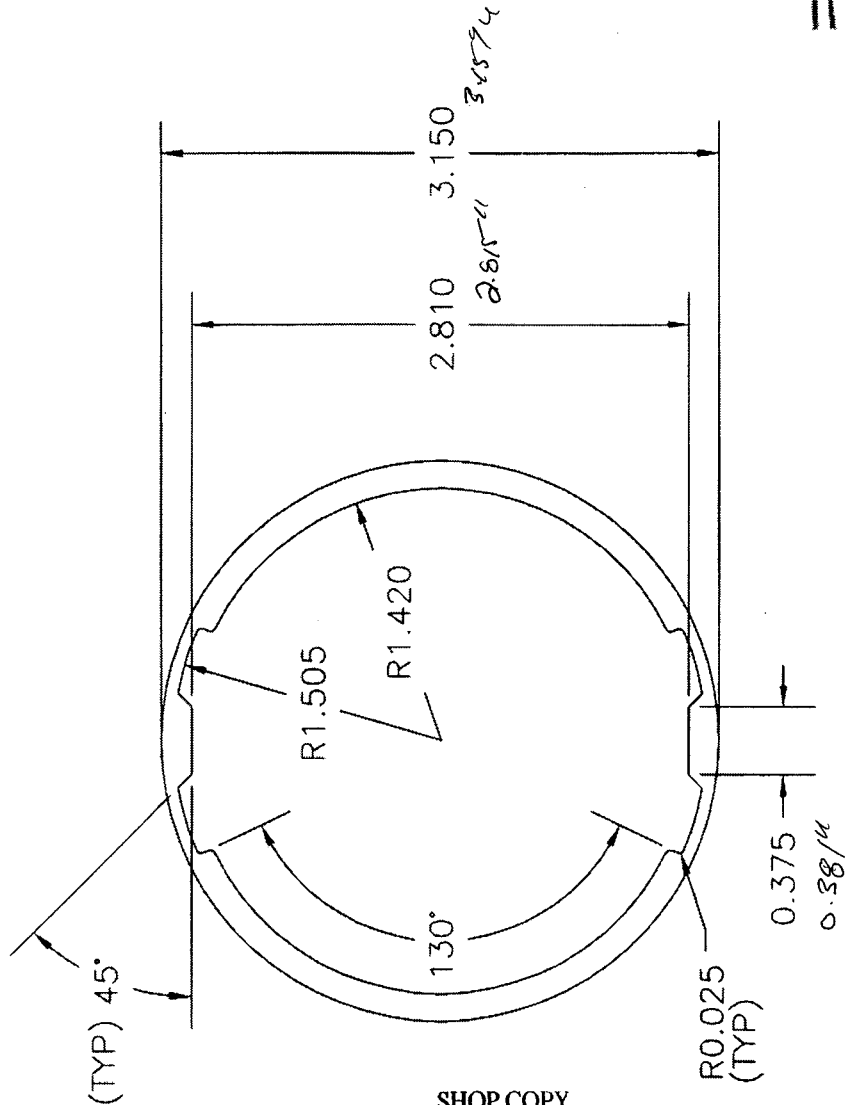
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 16.0" LONG)





DESIGN <i>DAK</i>	DRAWN BY <i>DAK</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>JA</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1

RELEASED  
98.8.25 DS



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NO. \_\_\_\_\_

D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859  
OR BON L DIE # 897122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (E.G. D2600-3-120 IS 120 INCHES)

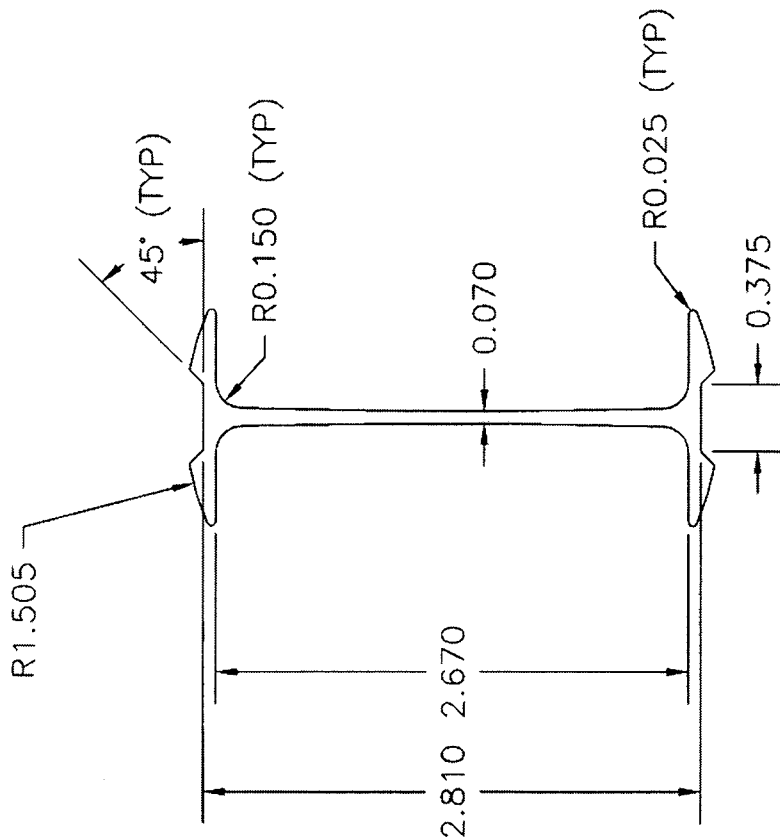






DESIGN <i>DR</i>	DRAWN BY <i>DR</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED  
98 8 25 DS



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WITHOUT NOTICE  
WORK ORDER  
NO. \_\_\_\_\_

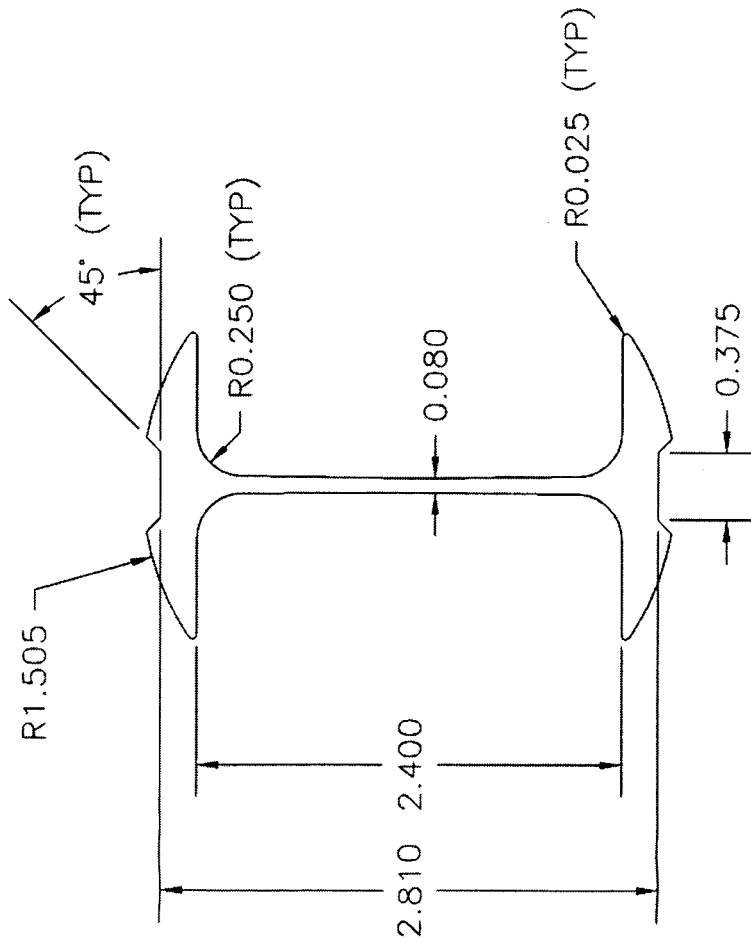
D2600-5  
MANUFACTURED WITH CARADON INDALEX DIE # MS-18871  
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-5-108 IS 108" LONG)





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. 0 SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED  
98.8.25 DS



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WITHOUT NOTICE  
WORK ORDER  
NO. \_\_\_\_\_

D2600-7  
MANUFACTURED WITH CARADON INDALEX DIE # MS-18872  
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(E.G. D2600-7-125 IS 125" LONG)



ACCT# 00046024

INVOICING COMPANY AND LOCATION  
SIGNATURE ALUMINUM CANADA  
1850 CLEMENTS ROAD  
PICKERING ON L1W 3R8

**SHIPPING MANIFEST**

MANIFEST DATE  
03-16-09  
MANIFEST NUMBER  
656328  
SALES ORDER NUMBER  
44198

REFER TO  
THESE NUMBERS ON  
ALL CORRESPONDENCE

CREDIT REP  
HAMBROOK, PAU  
905-508-3250

SALES REP

FIELD SALES REP  
Kutter A  
450-435-6551

CUST SERVICE REP  
Burton D  
905-427-2227

TERMS / FREIGHT  
O / P

SHIP TO  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY ON  
K6A 1K7 CN  
PHONE 613-632-5200

SOLD TO / PURCHASER  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY ON  
K6A 1K7 CN  
PHONE 613-632-5200

CUSTOMER ID 46024  
ORDER DATE 02/24/09  
CUSTOMER PO NUMBER 8262

LOCATION PIC 57392  
SALESMAN 59358  
JOB

BILL OF LADING NUMBER  
08390042

ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER CUSTOMER PART NUMBER	ALLOY & TEMPER LENGTH CUTTING TOLERANCE	FINISH DESCRIPTION FABRICATION DESCRIPTION SHIPPING TOLERANCE	THIS SHIPMENT			UNIT	QUANTITY
							NBR OF PKGS	GROSS POUNDS	NET QUANTITY		
01	69	KG	0	DAA-897122-1 D2600-3-120  LOT/TKT DETAIL:	6061 /T6 120" +3/16 " -0 "	MILL CERTIFICATE OF COMP (+015-015,0079-0058)  44198010 / 306427 44198010 / 306428	2	561	547	KG	39
		M	0						234.70	M	38
		PC	0						77	PC	77
							1	284	277		
							1	277	270		
TOTALS							2	561	547	KG	
									234.70	M	
									77	PC	

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.  
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

# CERTIFICATE OF COMPLIANCE

## SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD  
PICKERING, ON L1W 3R8

Cert Date	Cert No	Sales Order	Page
03/16/09	188667	44198	1
Cust PO	B/L No	Lot	Date
8262	08390042	44198010	3/16/09

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897122-1	120" Mill 6061 T6	D2600-3-120
Gross Weight	561 KGS		
Net Qty	547 KG	77 PC	235 M 2 PKG
Specification	Die Desc		
AMS-QQ-A-200/8 & ASTM B221-08			

Mechanical Tests:						
Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW	
1	319.7 / 46.4	294.2 / 42.7	13.7	.0	96	

Chemical Analysis:							
SI	FE	CU	MN	MG	CR	ZN	TI
.62	.30	.26	.04	.87	.06	.14	.01

*S*  
*0403/18*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Conchita Ko, QA Manager Signature Aluminum Canada Inc

*Conchita Ko.*